Work Orde July-09-13 12:5		04400		*104400*								
Revision ID:	D4061-1	OM.	A	Accept	*N900	040	100)* s	etup S		JS1* JS2*	
Start Date: Required Date:	7/04/13 7/09/13	Start Qty: 12.00 Req'd Qty: 12.00	• •		Cust Item II Customer:	D:					NS/"	
Approvals:	Process P	lan: MLJ	Date: \3~07-10	Tooling: SPC (Y/N):		ite:		R		Start * Stop *	NR1* NR2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty	t Reject Numbe		
Draw Nbr	Re	evision Nbr										
D4061	В											
100 *1 Mill Conv		Memo		0.00	Mest	13/07/2	22	//	/	<i>f</i>		
Conventional Millin	g Machine	1-Turn as FOLIO R DWG RE	per folio FA914 & dwg EV:									
110		QC2- Inspect parts of	f machine FAI/FAIB	0.00						~		
110 QC Quality Control		Memo		0.00	MJP 13/0	07/22						

DQA:	Date:								DART				
QA Closed:	•		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE
						DISPOSITION					PARTMENT	·	1
Work Orde	er: _						.			_	· · · · · · · · · · · · · · · · · ·		, ,
						Rework			Skid-tube Crosstube		_	Water Jet	Engineering
Part N	art No.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality
NCD N	J.					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No.				Suspected Unapproved]		Large Fab	Composite		Supplier			
Root					Desci	ription of work order update		nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling				!									
Handling/Pre						•							
Material													
Operator	Н	°											
Offset/Setup													
Process .	Н												
Supplier	\vdash												
Training							1						
Transport	H												
Unapproved		<u> </u>			<u> </u>		EAI	HT CA	I TEGORY		1		<u> </u>
Landi	ng (Gear				General	17	OLI CA	ILGORI				
		Bending				Bend	Г] Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	ļ	Set-up
	\vdash	Cracks				Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorred	—	Temperature/Cure
	\vdash	Crimp/Kir	nk/Ripple	/Wave		Burrs	H	1	ion Incomplete/Un	gualified	Part Lost/Mi	 	Weld
	\vdash	Cuffs		-		Contamination	一	1	tions Incomplete/U	· —	Part Moved	· ·	Wrong Stock Pulled
		Crushing				Countersink	Г	4	ned/off center		Positioned V		
	_	Heat Trea	at			Cut Too Short	Г	Mislabe			Power Loss/	_	Other
		Inspectio	n Strip in	Tube		Drawing	Г	Misread			<u>.</u>	· _	
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Twist in Tube				Fit/Function		Out of	Sequence				

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Work Orde July-09-13 12:5		4400		*104		Page 2					
Item ID: Revision ID: Item Name:	D4061-1 SKI CUSHIO	N		Accept	*N90004010)* s	etup St St	art *N	S1*
	7/04/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:				IN	.J/
Approvals:		n:		Tooling: SPC (Y/N):		ite:		F		op .	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID WL 13/071	Tool#	Plan Code	Accept Qty	Reject Qty	Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ck Location 5745	0.00				16x			30
¹⁴⁰ *1⊿∩* ^{QC}		QC21- Final Inspection -	Work Order Release	0.00					131	7/24	4)

Quality Control

10000

DQA:	Date:								™ ∆APT						
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / UP		ork Order up	odate only	AEROSPACE		
						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er: _					·				,					
D N	1					Rework		Skid-tube Crosstube			D	Water Jet	Engineering		
Part N	10			<u> </u>		Scrap Use-as-is			Machining noforming	Small Fab Finishing	-1	d. Eng. Coor. re/Packaging	Quality Other		
NCR N	do.					Suspected Unapproved		mem	Large Fab	Composite	Kec/Stoi	Supplier			
WCIV I	•••					Suspected onapproved			Large rab	composite		3applier [
Root					Desc	ription of work order update		nitial	Acti	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector		
Design										-					
Doc/Data															
Equip/Tooling															
Handling/Pre											,				
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training						**									
Transport													·		
Unapproved															
							FAI	ULT CA	regory			·········			
Landi	ng Ge	ear				General		_			_		_		
		Bending			L	Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
	Щ°	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure		
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld		
	Щ°	Cuffs			Contamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled			
	Щ́	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_		
	╚	Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
		nspectio	n Strip in	Tube		Drawing		Misrea	d						
	\bigsqcup '	Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
	L	Wave/Twist in Tube Fit/Function				Fit/Function		Out of	Sequence						

Work Order ID:

104400

Parent Item:

D4061-1

Parent Item Name:

SKI CUSHION

Start Date: 7/04/13

Required Date: 7/09/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC

IPP REV:B 11.01.10 AS PER

	DWG REV.B DD	VERF:EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	62.7600	0.4125	5.210526			

UHMW U-Channel

Location	Loc Oty	Loc Code
ST202	6.4	3,687'
91102	6.4	
ST209a	56.36	
103403	20	A 3,916'
103786	12	/ <u>'</u>
97824	24.36	

JUSP 13/07/22

DQA:			Date:										™ ∆APT
QA Closed:			Date:			WORK ORDER NON-	-C(ONFOI	RMANCE / UI		Vork Order up	odate only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	Part No.				Rework Scrap			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR I	No.					Use-as-is Suspected Unapproved		mem	Large Fab	Composite	Hec/3tol	Supplier	J Other
Root					Desc	ription of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design						•							
Doc/Data													
Equip/Tooling													
Handling/Pre							l						
Material													
Operator													
Offset/Setup							1						
Process					<u> </u>								
Supplier											1		
Training													
Transport													
Unapproved				:									
							FA	ULT CA	regory		•		
Landi	ng (Gear				General							
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
į		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
		Cuffs	•			Contamination		Instruct	tions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled
i		Crushing				Countersink		Misalig	ned/off center		Positioned \	Vrong	-
	-	Heat Trea				Cut Too Short		Mislabe	•		Power Loss/		Other
	-	Inspectio		Tube		Drawing		Misrea		_		- L	,
	-	Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish	Out of Calibration						
		1	- · · · · · · · · · · · · · · · · · · ·			Fit/Function	Out of Sequence						

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DART AEROSPACE LTD	Work Order:	104400
Description: Ski Cushion	Part Number:	D4061-1
Inspection Dwg: D4061 Rev: B		Page 1 of 1

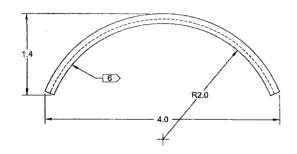
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.95	+/-0.030	4,973			MJP-04	Vern
0.17	+/-0.030	0.156			111	111
1.050	+/-0.010	1.055			//!	//1
0.10	+/-0.030	0.098	1		(1)	///
0.076	+0.015/-0.000	0 088			111	,,,
1.25	+/-0.030	0,156 1,055 0,018 0,088 1,254	V		///	. , 1)
				A		
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Measured by:	Audited by:	mf	Preliminary Approval:	
Date: 13/07/12	Date:	3/07/22	Date:	

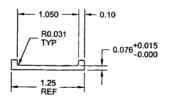
Rev	Date	Change	Revised by , Approved
Α	11.02.11	New Issue	KJ 9X X
72.2			

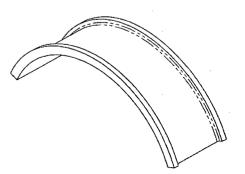
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<u>D4061-1 412 SKI CUSHION</u> (MAKE FROM D4061-1F)

UNCONTRACT STERET Market Commence 104400 MCS





DELEASED 2010 -12- 23 20

NOTES: 1) MATERIAL: MAKE FROM D4287-3 B 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 047) WEIGHT: 0.02 lbs
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7

№ D4061-1F FLAT MACHINED STATE

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							ı
В	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF. PART0-29.				мв	10.12.07	
A	NEW ISSUE					10.03.31	
REV.				DESCRIPTION	BY	DATE	l
DESIGN	N DART AEROSPA			ACEUD		مِ ا	
DRAWN 4		ζ	HAWKESBURY, ONTARIO, CANADA			1	
CHECK	ED	5	E.	DRAWING NO.		REV. B	
MFG. A	PPR.	. 1	Z~	D4061		SHEET 1 OF 1	ĺ
APPRO	VED	$\mathbb{Z}_{\mathcal{U}}$	7	TITLE		SCALE	
DE APP	R.	4	#	412 SKI CUSHION		NTS	ĺ
DATE 10.12.07				COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS GOOLMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE COPYRIGHT OF THAT IT IS NOT TO BE USED FOR MAY PURPOSE OR COMPED OR COMMANDALTED TO ANY OTHER PERSON WITHOUT WITTIN PERSONS AND MART ARROSPACE LTD.			

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